



LubriOne™ PC-15GF/10T-2S FR V0 BK702

Polycarbonate

Key Characteristics

Product Description	
Glass Fiber Reinforced, PTFE and Silicone Lubricated, Non-halogen Containing Flame Retardant Polycarbonate Compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber
Additive	• PTFE + Silicone Lubricant
Features	• Flame Retardant • Halogen Free • Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.35	1.35	ASTM D792
Molding Shrinkage (0.118 in (3.00 mm))	0.20 to 0.50 %	0.20 to 0.50 %	ISO 294-4
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	13800 psi	95.0 MPa	ASTM D638
Flexural Modulus ³	587000 psi	4050 MPa	ASTM D790
Flexural Strength ³	20300 psi	140 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact 73°F (23°C), 0.126 in (3.20 mm), Injection Molded	2.8 ft·lb/in	150 J/m	ASTM D256A
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	275 °F	135 °C	ASTM D648
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	> 1.0E+12 ohms	> 1.0E+12 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.13 in (3.2 mm))	V-0	V-0	UL 94

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	230 to 266 °F	110 to 130 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Processing (Melt) Temp	536 to 590 °F	280 to 310 °C
Mold Temperature	176 to 248 °F	80 to 120 °C

Injection Notes

Injection Pressure: MED-HIGH

Hold Pressure: MED-HIGH

Screw Speed: MODERATE

Back Pressure: LOW

Notes

¹ Typical values are not to be construed as specifications.

² 0.20 in/min (5.0 mm/min)

³ 0.051 in/min (1.3 mm/min)



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